

order 1816

22 FEB



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBT18560-11
Job Sheet 170255



Part No: RBT18560-11

Job Qty: 12 ea

Part Name: Upright



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/12/18

Job Tracking No:

Due Date: 1/31/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBT18560 Rev4 IPP Rev A 17.11.13 New issue DP verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea		1/30/18	0.00	0.00	Start Up Machining-4		SL 18-1-25
110	CNC Lathe	12 pcs		1/30/18	0.00	3.00	MORI SL-154		SL
120	QC	12 pcs		1/30/18	0.00	0.00	QC2		SL
130	QC	12 pcs		1/30/18	0.00	0.00	QC8		SL 18-01-28
135	HandFinish	12 pcs		1/31/18	0.00	1.20	HandFinish7		DEB 18-01-29
140	QC	12 pcs		1/31/18	0.00	0.00	QC5		38
150	Outsource	12 pcs		1/31/18	0.00	0.00	Outsource12		AT 18-01-14
160	Packaging	12 pcs		1/31/18	0.00	0.00	Packaging2		AT 18-01-14
170	QC	12 pcs		1/31/18	0.00	0.00	QC6		JAS 38
180	Packaging	12 pcs		1/31/18	0.00	0.00	Packaging3		6 9-88
210	QC21-SA	12 Ea		1/31/18	0.00	0.00			FEB 15 2018

Part Op 110 - 1-Machine as per DWG. FOLIO REV: AA DWG REV: 4 2-Debur

Descriptions: 135 - Bead blast

150 - Issue P/O to Groupe Altech; PO 038918 -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required

FEB 20 2018

JAN 31 2018

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M1018R0.500	3	34	0	0
	5018011	3.6			

Part Specifications

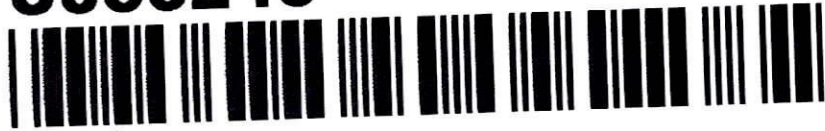
Specifications could not be found.

Plex 1/12/18 10:49 AM Dart.lajeunesse.marie

213

DART
AEROSPACE
S035243

Dart Aerospace Ltd.
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CANADA
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Upright

PART NO: RBT18560-11

Original Serial #: S035243

Revision:

Operation:

Change No:

Start up Operation 01/25/18

Job No: 170255

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



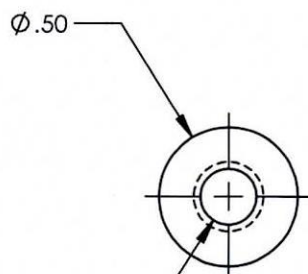
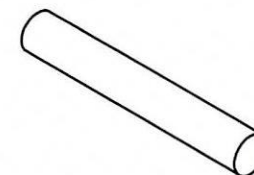
QA Closed: _____ Date: _____

Work Order update only ☐

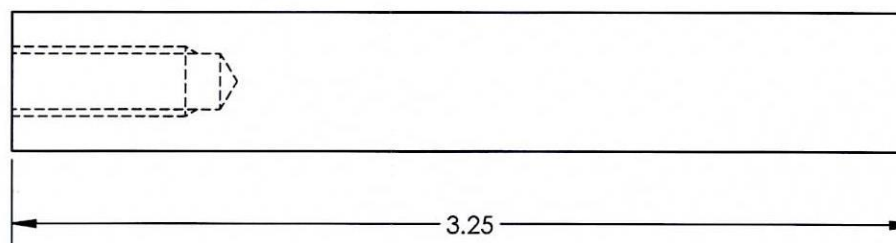
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



1/4-20 UNC - 2B ∇ .63



SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 170 251 M.C.
1801-12

(-11)

UPRIGHT

DART AEROSPACE	
TITLE ENGINE/GEARBOX SEAL PULLER	
DWG NO. RBT18560-11	REV 4
MAT'L 1018/1020 CR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT	.XXX $\pm$.005 FRACTIONS $\pm$ 1/8
TREAT	.XX $\pm$.01 ANGLES $\pm$ 5°
FINISH BLACK OXIDE	.X $\pm$.1 SURFACES = 125/
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: COLE	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED:	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR:	USED ON MODEL
QA APPR:	SEE SHT 1
APPROVED: WEIL	
SCALE 3:2	DATE 5/2/2002
SHEET 6 OF 6	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER
PO038918

Supplier:

GRO02-VC
Group Allech
2455 Halpern
St Laurent
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Ship To:

1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No:

PO038918

PO Date:

1/31/18

Due Date:

2/8/18

Purchase Order

Revision:

Revision Date:

Baker, DianePhone:
dbaker@dataero.com

Ship-To Contact:

Via:

Ground

Pynt Terms:

Net 30

Freight Terms:

Special Comments:

Items

Line	Item	Job	Part	Description	Status	Due	Order	Received	Balance	Unit	Extended
1	169927	RBW6405G02131-Bolt	3G-1	-Issue P/O to Groupe Allech: P/O -Zinc plate, ASTM B633 TYPE 1 SC2 - Certificate of Conformity is required	Firmed	2/8/18	2 pcs	0 pcs	2 pcs	\$3.00/pcs	\$6.00
2	170013	RB6796941-14		Starter Seal Guide -Issue P/O to Groupe Allech: PO -Black oxide finish, MIL-C- 13924C Class 1 -Certificate of Conformity is required	Firmed	2/8/18	5 pcs	0 pcs	5 pcs	\$2.49/pcs	\$12.45
3	170165	647.7701		Strut Assembly Issue P/O: Group Allech CAD PLATE IAW QQ-P-416F CLASS I TYPE II note: cad plate should not be too thick around tread Upright -Issue P/O to Groupe Allech: PO -Black oxide finish, MIL-C- 13924C Class 1 -Certificate of Conformity is required	Firmed	2/8/18	10 pcs	0 pcs	10 pcs	\$6.00/pcs	\$60.00
4	170255	RBT18560-11		Hammer Head -Issue P/O to Groupe Allech: P/O -Zinc plate, ASTM B633 TYPE 1 SC2 -Certificate of Conformity is required	Firmed	2/8/18	6 pcs	0 pcs	6 pcs	\$2.39/pcs	\$14.34
5	170360	RBW109-3101-58-1-3		Strut Assembly Issue 16 pcs	Firmed	2/8/18	16 pcs	0 pcs	16 pcs	\$75.50/pcs	\$1,208.00

DAS
38
9-89



Certificat de Conformité / Certificate of Compliance

(006394-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
Tel: 514-335-3666 Fax: 514-335-3868

www.groupaltech.com

Bon de Livraison / Packing Slip

006394 - 1

Livré à / Ship to

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

BUYER:

Date expédition Ship date		Créé Par Generated By		Transport / No de Compte Courier / Acc. No.		Bon de commande Client Customer Purchase Order No.			
14-Feb-2018		Curtis Anderson				038918			
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order	
1	RBW6405G02131-3G-1 Rev.	BOLT 01 -ZINC-CLEAR TRI [ZINC CLEAR TRIVALENT] SPÉC: ASTM B633 TYPE 1 SC2 ***	ZINC CH	2	2	0	0	0	
2	RB6796941-14 Rev.	PLUG BLACK OXIDE MIL-C-13924C CLASS 1	BLACK-OXIDE CH	5	5	0	0	0	
3	647.7701 Rev.	647.7701 CAD PLATE IAW QQ-P-416F CLASS 1 TYPE 2 CAD PLATE SHOULD NOT BE TO THICK AROUND TREAD	CADMIUM CH	10	10	0	0	0	
4	RBT18560-11 Rev.	RBT18560-11 BLACK OXIDE FINISH MIL-C-13924C CLASS 1	OXIDE-BLACK CH	12	12	0	0	0	
5	RBW109-3101-58-1-3 Rev.	RBW109-3101-58-1-3 01 -ZINC [ZINC] SPÉC: ASTM B633 TYPE 1, SC2 *** SPÉC: CONFORMITY IS REQ. ***	ZINC CH	6	6	0	0	0	
6	647-7703 Rev.	647-7703 CAD PLATE IAW QQ-P-416F CLASS 1 TYPE II	CADMIUM CH	16	16	0	0	0	
7	RBW109-3101-58-1-3 Rev.	RBW109-3101-58-1-3 01 -ZINC [ZINC] SPÉC: ASTM B633 TYPE 1, SC2 *** SPÉC: CONFORMITY IS REQ. ***	ZINC CH	6	6	0	0	0	
8	RBW6405G02131-3G-1 Rev.	BOLT 01 -ZINC-CLEAR TRI [ZINC CLEAR TRIVALENT] SPÉC: ASTM B633 TYPE 1 SC2 ***	ZINC CH	2	2	0	0	0	

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
Our financial and legal responsibility will not be higher than the amount of invoice.